

Date: Monday, 2/19/2007 8:07:23 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 30745		
Estimate Number	: 12667		
P.O. Number	: N/A	Part Number	: D323825
This Issue	: 2/19/2007 S.O. No. : N/A	Drawing Number	: D3238 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30686	Material	: N/A
Written By	:	Due Date	: 2/26/2007 Qty: 16 Um: Each
Checked & Approved By	: <u>07.02.19</u>		
Comment	: Est Rev: A New Issue 07-01-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0252 sf(s)/Unit Total : 0.4032 sf(s)

M2024-T3 .080 Sheet

Batch: M18481

ml

03/02/22

(18)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: BProg Rev: B

ml 07/02/22

2-Deburr if necessary

(18)

\*\*\*\*\*USE D3238 BLANK CUTTING FILE\*\*\*\*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine Serration on Sheet using DT8934 PLATE

07-02-20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07-02-20

5.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: BProg Rev: B

ml 07 02 22

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: DP Date: 07/02/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30745

Part Number: D323825

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Deburr if necessary

\*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*

*ml 07 02 22*

(18)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



*ml 07 02 22*



(18)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*yl 07/02/22 x 18*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Pe 7/2/22 (18)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5

*Pe 7/2/22 (18)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

*07/02/22*

Job Completion



*W 07/02/22*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

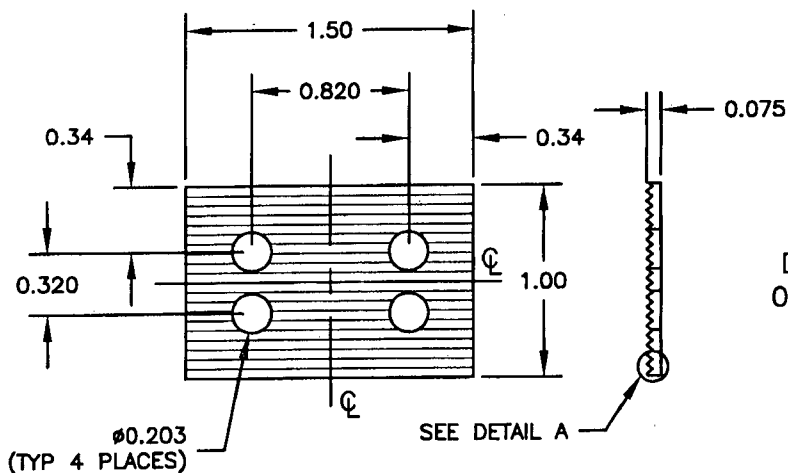
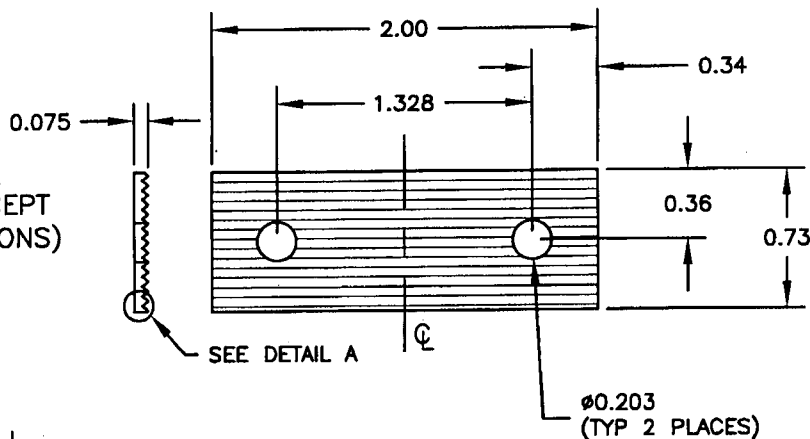
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 1 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	

**D3238-1 PLATE (SHOWN)**  
D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**  
D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**RELEASED**

07.01.22

**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/4 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\phi$

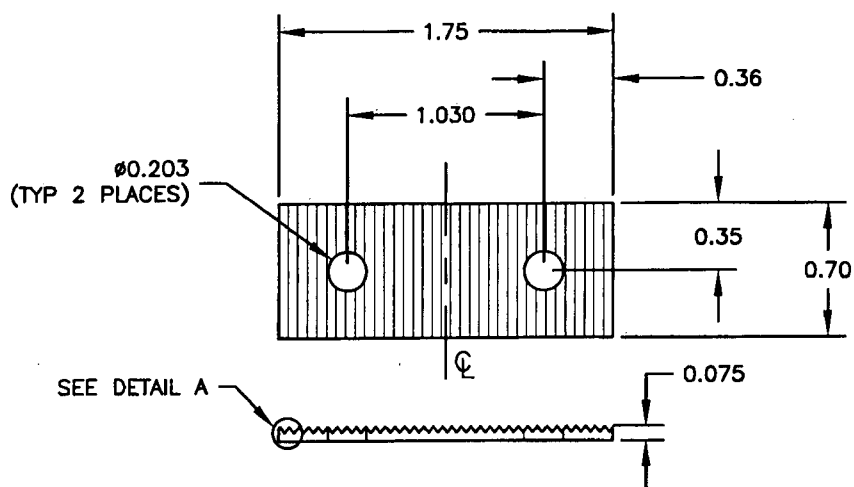
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30745

**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



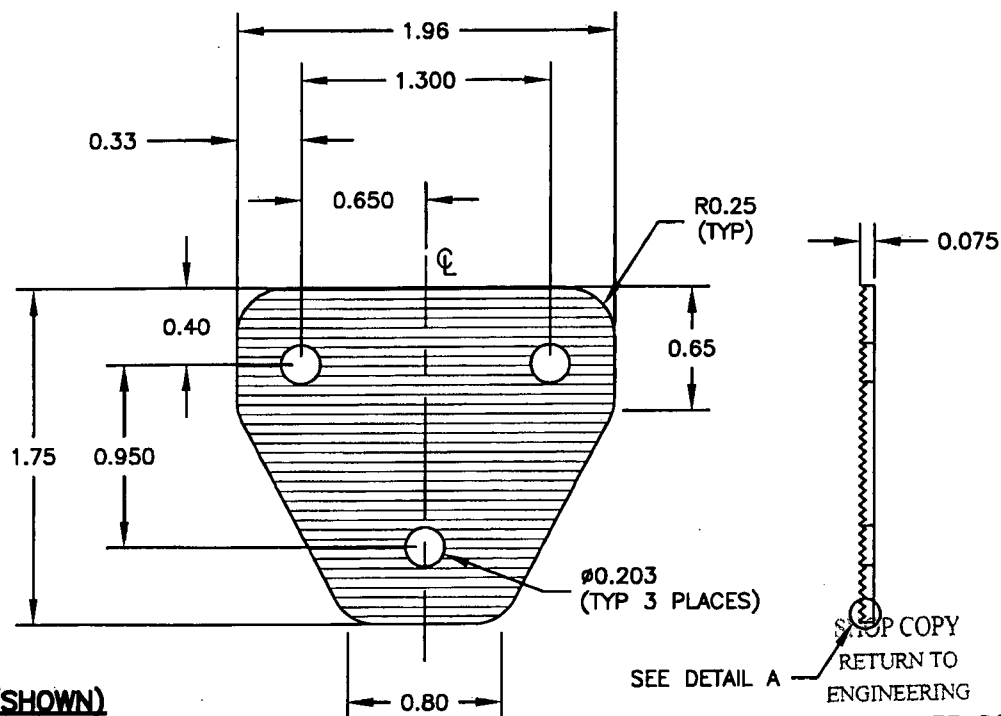
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 2 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1



**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

RELEASED

07.02.17



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

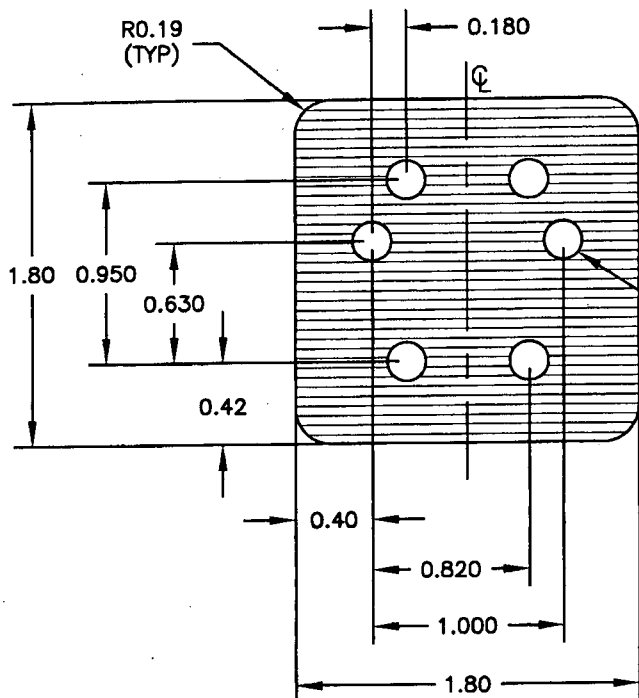
STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30745

Copyright © 2003 by DART AEROSPACE LTD

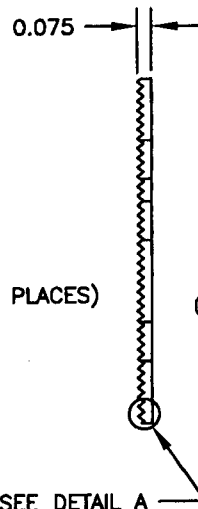
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 3 OF 3
DATE 07.01.17	TITLE PLATE		SCALE 1:1



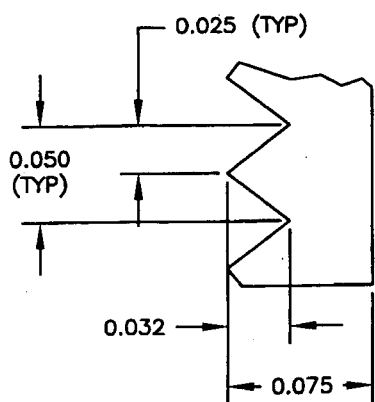
Ø0.203  
(TYP 6 PLACES)



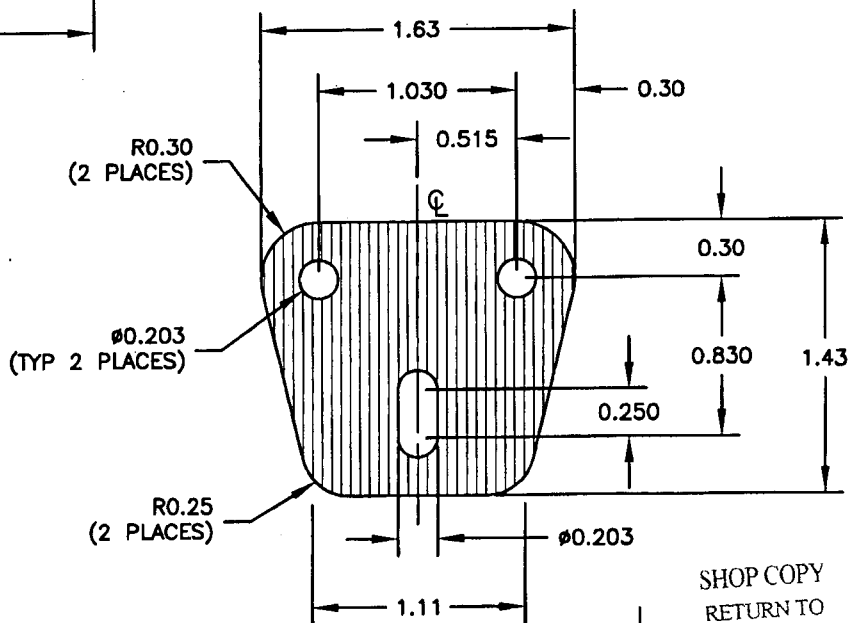
RELEASED

07.01.22

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30745

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	30745
<b>Description:</b> Plate	<b>Part Number:</b>	D3238-25
<b>Inspection Dwg:</b> D3238 , <b>Rev:</b> B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	md: <i>md</i>
Date:	07 02 22

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	